

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023394**Date Inspected:** 26-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath. Math. was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG ASSMEBLY # BAY 14

Segment No. 7BW

Submerged Arc Welding (SAW) of weld joint – SEG 035*-001 for Deck Plate DP-088-001 to DP-115-001 in progress. Welder is identified as 045265. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS –B-T-2221-B-L2C-S-2.

Segment No. 7EW

Submerged Arc Welding (SAW) of weld joint – SEG 116A1*-001 for Deck Plate WDP-091A to WSD116A in progress. Welder is identified as 045265. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS –B-T-2221-B-L2C-S-2.

WELDING INSPECTION REPORT

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Segment No. 031B

Shielding Metal Arc Welding (SMAW) of weld joint – SEC 031B-024, 009 and 010 in progress. Welder is identified as 068097, 066361 and 037840. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS –B-T-2214-T-C-U4b-FCM.

Segment No. 7CW

Flux Cored Arc Welding (FCAW) of weld joint – SEG 037B-004 in progress. Welder is identified as 201215. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS –B-T-2231-T-C-U4b-F.

Segment No. 6AW

Flux Cored Arc Welding (FCAW) of weld joint – SSD30-PP-39.5-011 to 048 and 049 to 084 in progress. Welder is identified as 066477. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-T-2132 and WPS-B-T-2133.

Segment No. 6AW

Flux Cored Arc Welding (FCAW) of weld joint – SSD31-PP-38.5-011 to 048 and 049 to 084 in progress. Welder is identified as 066401. ZPMC QC is identified as Mr. Li Ming Yang and ZPMC CWI is identified as Mr. Shen Fu Yoo . The welding variables recorded by QC appeared to comply with the WPS-B-T-2132 and WPS-B-T-2133.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath
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Quality Assurance Inspector

Reviewed By:	Miller,Mark
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QA Reviewer
